

# Work Order ID 50143



Page 1

July 8, 2009 1:43:34 PM

Item ID: D3065-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 07/08/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 40.00



Customer:

## Reference:

Approvals: Process Plan: MF

Date: 09-07-08 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



## Sequence ID/ Work Center ID

## Operation Description

## Set Up/ Run Hours

## Draw Number

## Draw Rev.

## Plan Code

## Accept Qty

## Reject Qty

## Reject Number

## Insp. Stamp

Draw Nbr	Revision Nbr
D3065	Rev B

100

0.00



FLOW WATER JET

Waterjet

## Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065     Dwg Rev: B     Prog Rev: B     2-  
Deburr as required

43

HB 9-8-6

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

## Memo

0.00

Quality Control

HB 9-8-6

43

120



QC8- Inspect parts - second check

0.00

QC

## Memo

0.00

Quality Control

=> 80108010

counted  
+43

4

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Cust Item ID:

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Customer:

## Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



## Sequence ID/ Work Center ID

130



Small Fab

## Operation Description

Small Fab

## Set Up/ Run Hours

0.00

## Draw Number

## Draw Rev.

## Plan Code

## Accept Qty

## Reject Qty

## Reject Number

## Insp. Stamp

140



Brake NC

Brake NC

NC BRAKE

0.00

## Memo

Bend as per Dwg D3065

0.00

*EP 09/08/18* *SB 09/08/19* *43* *43*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

## Memo

0.00

*⇒ 09/08/19*

*(43)* *(43)* *✓*

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Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

160



HandFinish

Hand Finishing

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11 09/08/19

(43) 8

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Q.M. 09 - 08 - 19 (WB)

180



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

9/18/19

(43) 8P

# Work Order ID 50143

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Item ID: D3065-1

Accept

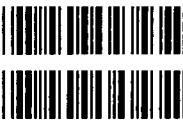


Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 07/08/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 40.00



Customer:

## Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

190



QC

Quality Control

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/24

MF 09-08-21

# Picklist Print

July 8, 2009 1:43:34 PM

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Work Order ID: 50143



Parent Item: D3065-1RevB



Parent Item Name: Step Spacer

Start Date: 07/08/2009

Required Date: 07/15/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	77.9100	5.2126			

2024-T3 .040 sheet

## Warehouse

### Location

#### Main Warehouse

MAT	77.91
110337	6.4
111381	4
111786	67.51

1(138)

H 9-8-6

DART AEROSPACE LTD	Work Order:	50143
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

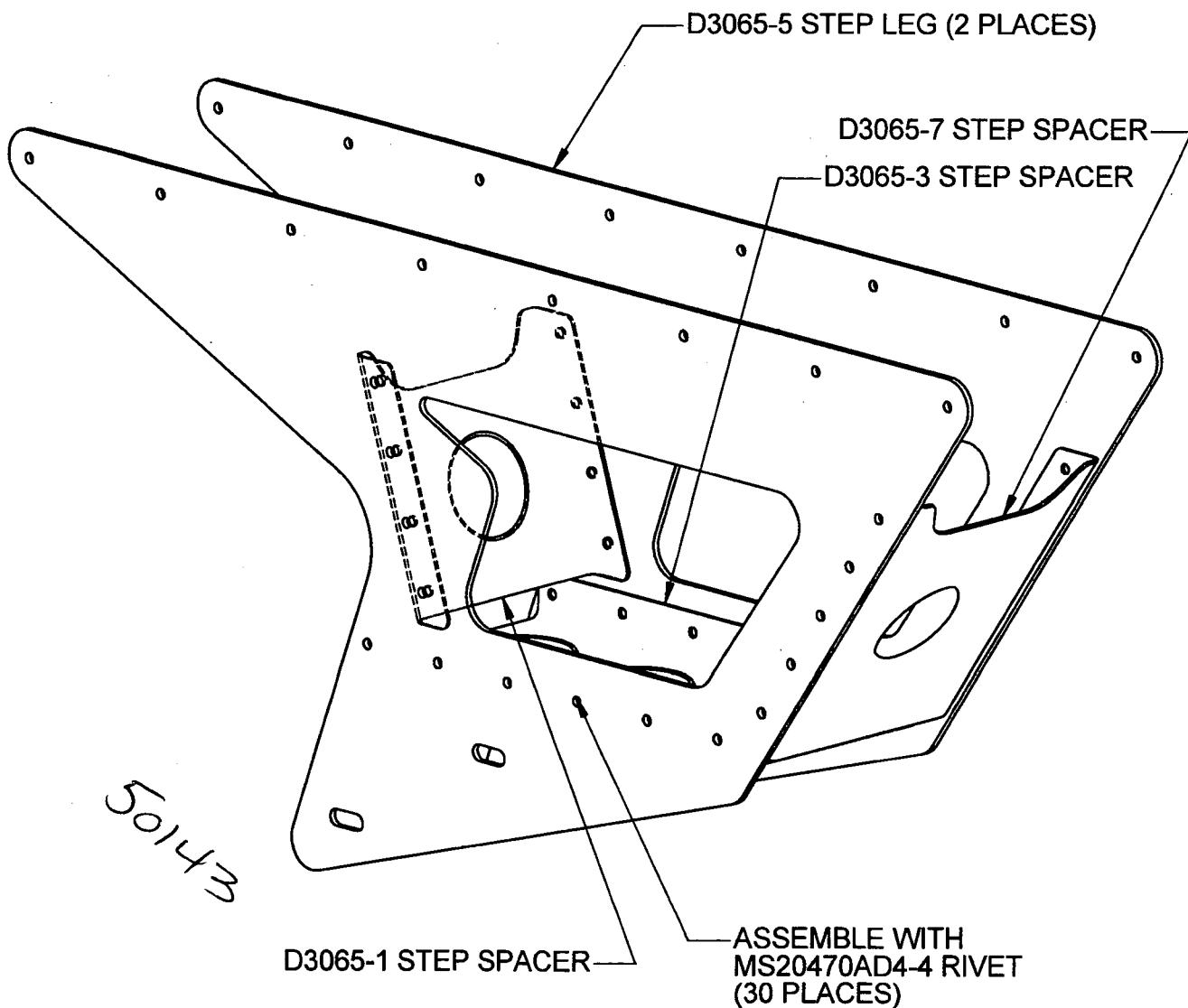
## X First Article      Prototype

Measured by:	<u>IR</u>	Audited by:	<u>S</u>	Prototype Approval:	<u>1</u>
Date:	<u>9-8-06</u>	Date:	<u>09/08/06</u>	Date:	<u>9</u>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	JM

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED***06.06.20 MM*

## **D3065-041 STEP LEG ASSEMBLY**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

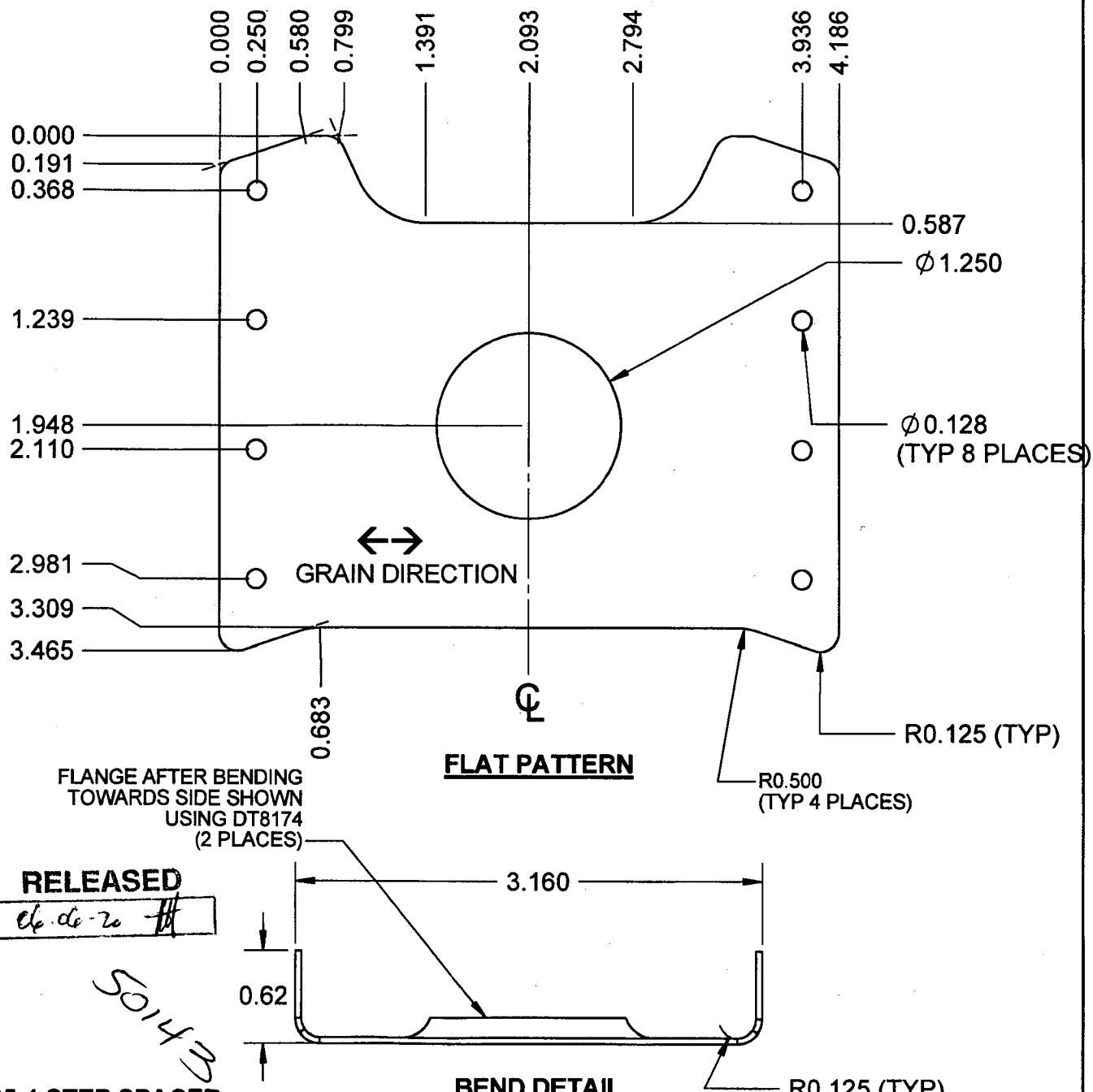
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1	



- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

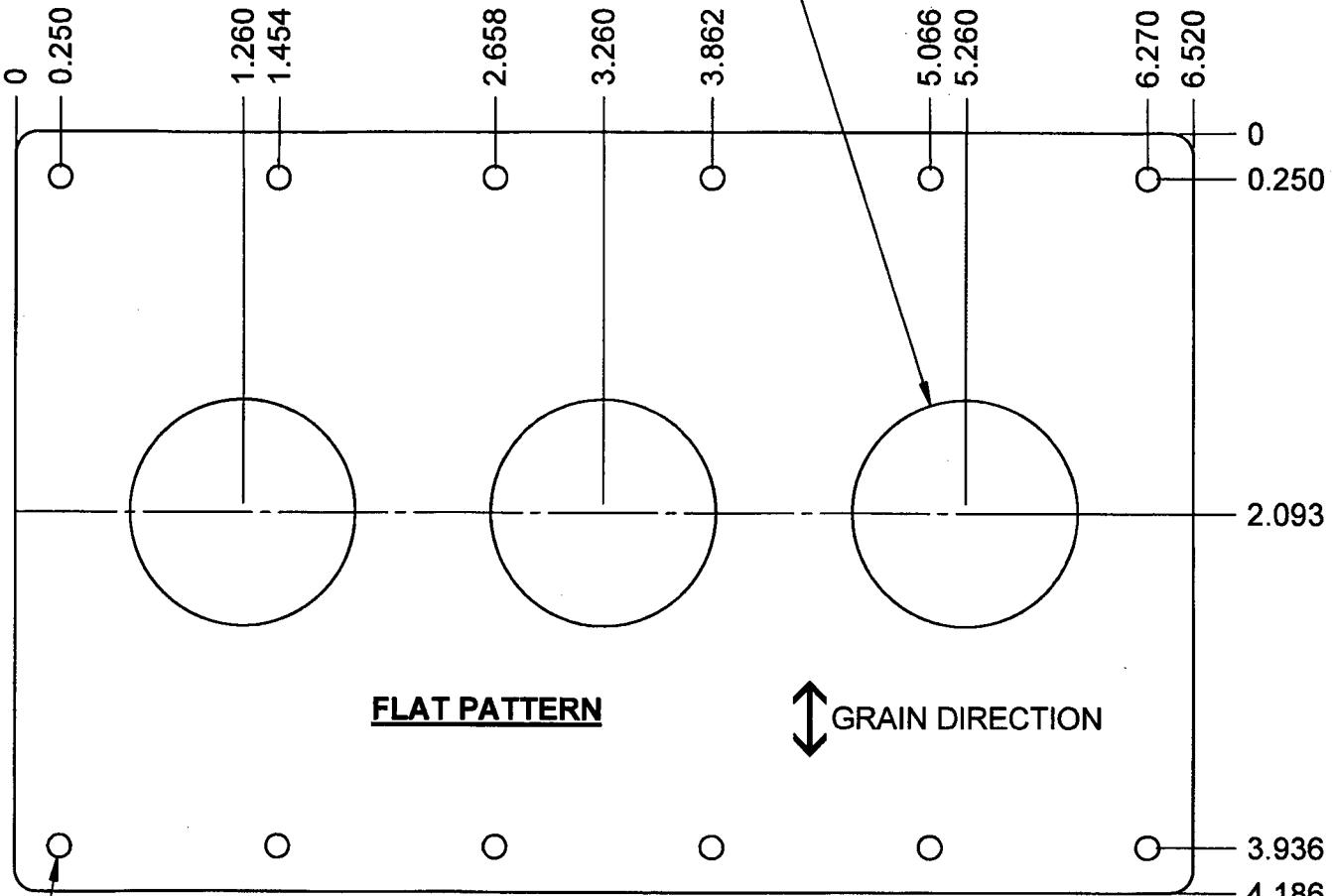
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1	

 $\phi 1.250$  (TYP, 3 PLACES)

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)  
 $\phi 0.129$  (TYP, 12 PLACES)

**RELEASED**

*do not cut*

**BEND DETAIL**

R0.125

### D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

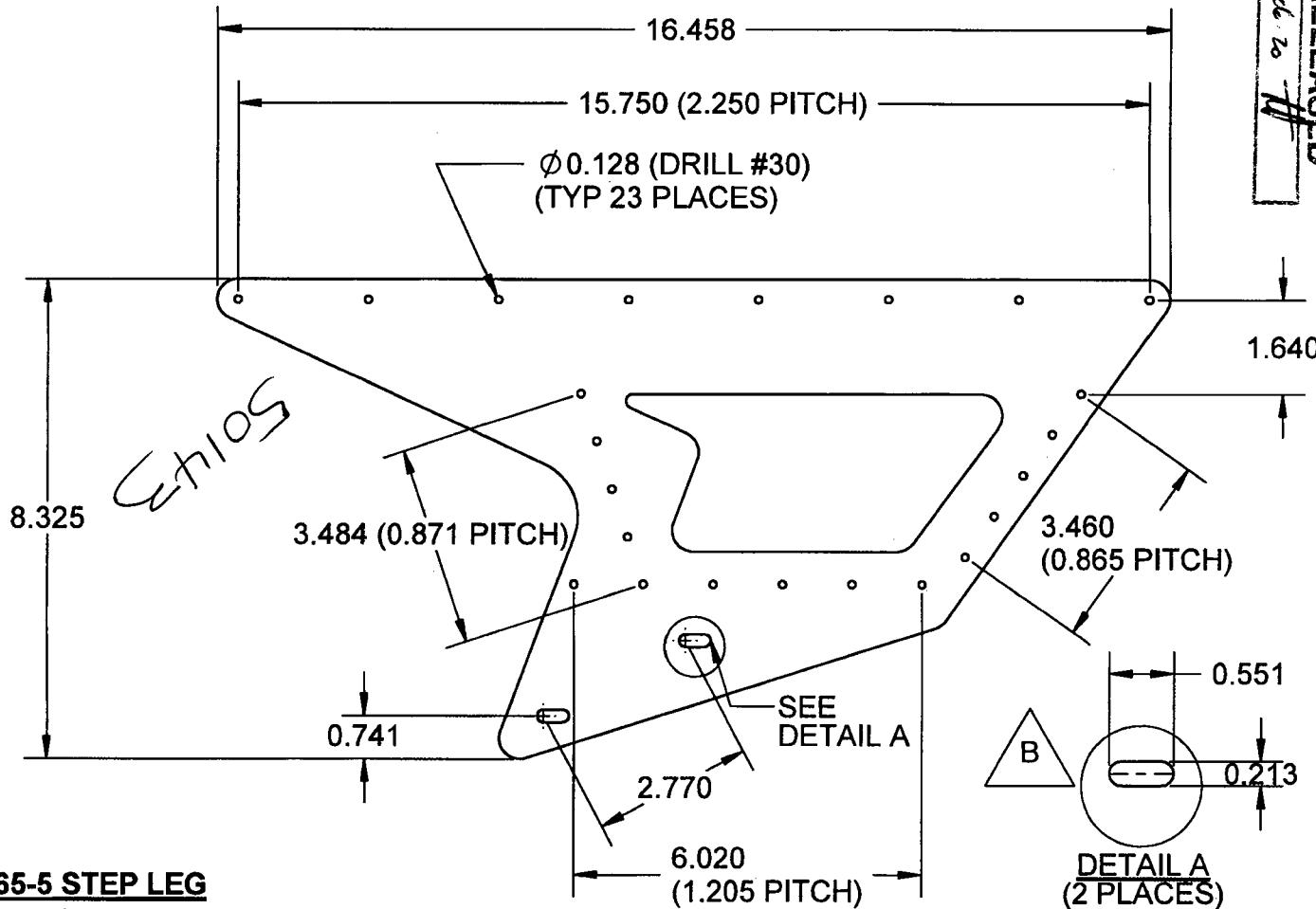
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
PH	M	DRAWING NO.
DATE	06.05.23	TITLE
		D3065 STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE
		1:3



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#### **D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

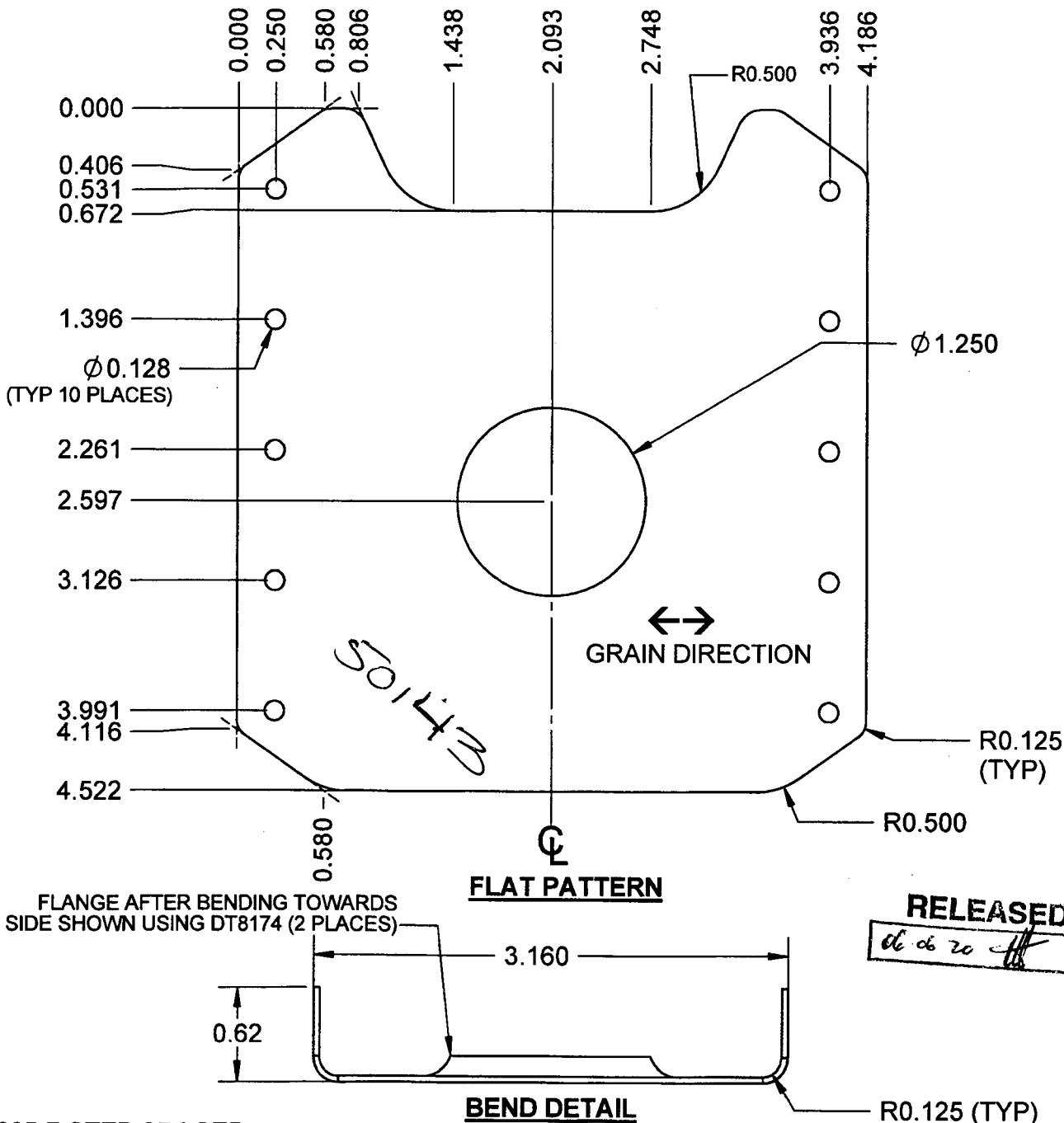
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries